

Work Order ID 119903

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119903

Page 1

Item ID: D205-634-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 1405-30

Tooling:

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580-041	G								

100

Document Control

0.00

100

DOCUMENT CONTROL

DC:

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG005

MLJ
140625 N/A

110

BENDING MACHINE - SKIDTUBES

0.00

110

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

DGL 14-6-11

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Item ID: D205-634-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube Fits LH or RH
 Start Date: 5/29/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/13/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for welding as per QSI 004								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
18
9-29

1 0 14-06-16

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Item ID: D205-634-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod *M129285*

2-Grind welds on step as per Dwg D2580

3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimation.

4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr

6-Drill pilot holes for aft cap using DT 8215Open-holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

150

QC10- Inspect visual per QSI004- ground welds

0.00

150

QC

Memo

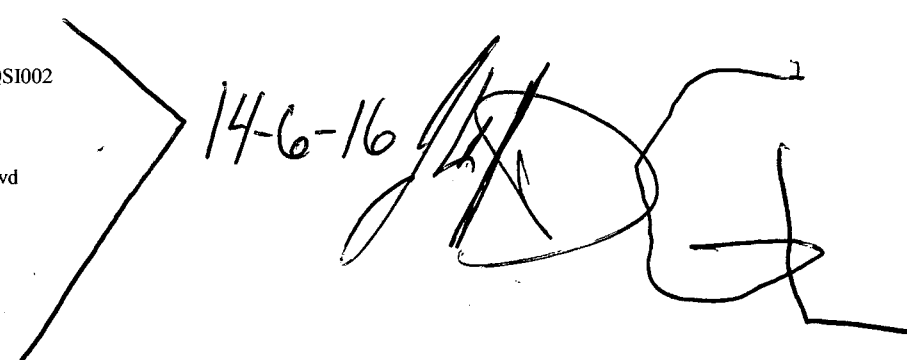
0.00

Quality Control

DAS
27
9-89

14/6/18

14-6-16



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Item ID: D205-634-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Pressure Wash per QSI005 4.3	0.00							
170									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.								
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
180									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:30 OVEN TEMPERATURE: 325 FINISH TIME: 9:00								

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Item ID: D205-634-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									

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15
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Item ID: D205-634-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube Fits LH or RH
 Start Date: 5/29/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/13/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
200		0.00							
HandFinish									
Hand Finishing	<div>Memo</div> <div>1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 11129457 Sikaflex expire date: 1111</div> <div>2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 RTU 598 Bk 11125792 exp 15106</div> <div>3-Inspect for foreign object per QSI 024</div> <div>4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 11129457 Sikaflex expire date: 1111</div> <div>5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 11129396</div>								

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Item ID: D205-634-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
220		0.00							
220	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-041								
	Location: _____								
	PPP Rev: <u>117773</u>								
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

DAS
16
9-89 14/06/24

JUN 24 2014

DAS
06
9-89

MLD 14-00-25

MF 14-6-24

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Work Order ID: 119903

119903

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS
PER ECN11-684 VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1		Manufactured	No			140	Each	740.0000	20	20			
---------	--	--------------	----	--	--	-----	------	----------	----	----	--	--	--

D4202-1

Spacer

Location	Loc Qty	Loc Code
----------	---------	----------

LG	737	
----	-----	--

113770	101	
--------	-----	--

117096	236	
--------	-----	--

118978	400	
--------	-----	--

LG001	3	
-------	---	--

105931	3	
--------	---	--

D2580-1		Manufactured	No			110	Each	10.0000	1	1			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2580-1

205 Bent Tube

Location	Loc Qty	Loc Code
----------	---------	----------

LG	10	
----	----	--

117898	6	
--------	---	--

119306	4	
--------	---	--

D2576-3		Manufactured	No			140	Each	43.0000	1	1			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2576-3

Step (Machining Detail)

Location	Loc Qty	Loc Code
----------	---------	----------

LG	43	
----	----	--

112978	43	
--------	----	--

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Work Order ID: 119903

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

31.0000

1

1

D2855

Cap

Handwritten: 14/06/24

Location

Loc Qty

Loc Code

FP001

29

105248

6

111897

23

ST019

2

10360

2

AN3-5A

Purchased

No

200

Each

320.0000

2

2

AN3-5A

Bolt

Handwritten: 14/06/24

Location

Loc Qty

Loc Code

GA

45

117423

45

ST511

185

m126559

92

m129246

93

ST512

90

124561

90

NAS1149D0332J

Purchased

No

200

Each

3,508.000

2

2

NAS1149D0332.J

Washer

Handwritten: 14/06/24

Location

Loc Qty

Loc Code

ST294

423

m128606

423

ST510a

3085

m128612

3085

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Work Order ID: 119903

119903

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130 AELS8-1032-130 Purchased No

200 Each 9,500.000 50 50

ALS7-1032-130 X

**

all 14/06/24

Rivnut

ALS4-1032-130

Location

Loc Qty

Loc Code

FG

100

121444

100

ST553

9400

M128649

9400

X50

AN3C4A Purchased No

200 Each 2,950.000 50 50

AN3C4A

**

all 14/06/24

Bolt

Location

Loc Qty

Loc Code

FG

20

122814

20

Return2014

9

124221

9

ST350

13

125388

3

M128606

6

M128739

4

ST350/513

26

M128606

26

ST512

3

124221

3

ST513

2879

M127410

1

M127832

62

M128634

816

M128879

2000

X50

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Work Order ID: 119903

119903

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

200

Each

5,750.000

50

50

NAS1149C0332R

WASHER

22 14/06/24

Location

Loc Qty

Loc Code

GA

825

125654

825

Return2014

41

122063

41

ST292

1726

124580

8

125654

8

m128591

1710

x50

st510

3158

m126319

61

m127306

2500

m127410

563

m127831

34

D3566-13

Manufactured

No

200

Each

19.0000

1

1

D3566-13

Gasket Fwd

22 14/06/24

Location

Loc Qty

Loc Code

FG

4

89050

4

B119343

x1

FP001

15

114917

3

116747

12

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Work Order ID: 119903

119903

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured

No

200

Each

30.0000

1

1

D3566-5

Gasket Center Aft

ll 14/06/24

Location

Loc Qty

Loc Code

FG

4

89219

2

94119

2

FP001

25

109492

1

116946

12

118931

12

vl

ST

1

116649

1

D3566-1

Manufactured

No

200

Each

29.0000

2

2

D3566-1

Gasket Fwd & Aft

ll 14/06/24

Location

Loc Qty

Loc Code

FG

14

100410

4

117012

4

89051

2

96430

2

98981

2

FP001

15

109785

1

117012

1

118946

13

B120350

x2

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Work Order ID: 119903

119903

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

D3564-11

Manufactured No

200

Each

9.0000

1

1

D3564-11

Stainless Steel Wearplate Aft

**

Handwritten: JH 10/06/20

Location

Loc Qty

Loc Code

FG

6

77056

4

85473

2

FP001

3

115694

3

Handwritten: xl

D3564-13

Manufactured No

200

Each

31.0000

1

1

D3564-13

Stainless Steel Wearpad Fwd

**

Handwritten: JH 10/06/20

Location

Loc Qty

Loc Code

FG

2

89044

2

FP001

5

114335

5

FP002

24

117119

12

118990

12

Handwritten: xl

D3564-9

Manufactured No

200

Each

10.0000

1

1

D3564-9

Stainless Steel Wearplate Fwd

**

Handwritten: JH 10/06/20

Location

Loc Qty

Loc Code

FG

6

76950

4

88407

2

FP001

4

115774

1

117036

3

Handwritten: ✓

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Work Order ID: 119903

119903

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 5/29/14

Required Date: 6/13/14

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

26.0000

1

1

D3564-5

Stainless Steel Wearplate Center Aft

all 14/06/24

Location

Loc Qty

Loc Code

FG

3

34806

1

89048

2

FP001

10

115655

10

FP002

13

116815

13

x1

D2594-3

Manufactured No

200

Each

1,065.000

16

16

D2594-3

O-Ring

all 14/06/24

Location

Loc Qty

Loc Code

FP001

1065

108402

156

110671

2

112234

3

113590

404

117822

500

x16

D2594-1

Manufactured No

200

Each

318.0000

16

16

D2594-1

Plug

all 14/06/24

Location

Loc Qty

Loc Code

FP001

301

112516

60

112727

32

115139

209

FP002

17

106252

17

x16

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LIST OF MATERIALS						PART NUMBER	DESCRIPTION
ITEM	QTY -041	QTY -045	QTY -047	QTY -049			
1	X					D2580-041	SKIDTUBE ASSEMBLY
2		X				D2580-045	SKIDTUBE ASSEMBLY
3			X			D2580-047	SKIDTUBE ASSEMBLY
4				X		D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1		D2500-1-190	EXTRUSION
21			16	16		D2570	BUSHING
22	1	1	1	1		D2576-3	STEP
23		4				D2579	SPACER
24	16	16	8	8		D2594-1	PLUG
25	16	16	8	8		D2594-3	O-RING
26	1	1	1	1		D2596	205 WEB
27	1	1	1	1		D2855	AFT CAP
28	1	1				D3564-5	WEARSHOE
29	1	1				D3564-9	WEARSHOE
30	1	1				D3564-11	WEARSHOE
31	1	1				D3564-13	WEARSHOE
32	2	2				D3566-1	GASKET
33	1	1				D3566-5	GASKET
34	1	1				D3566-13	GASKET
35	20	20	24	24		D4202-1	SPACER
36			1			D4406-041	WEARPLATE ASSEMBLY
37			1			D4406-043	WEARPLATE ASSEMBLY
37				1		D5061-1	FWD WEARPLATE
37				1		D5061-3	AFT WEARPLATE
50	50	50				ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50				AN3C4A	BOLT
52	2	2	2	2		AN3-5A	BOLT
53			8	8		AN4-45A	BOLT
54	50	50				NAS1149C0332R	WASHER (AN960C10L)
55	2	2	2	2		NAS1149D0332J	WASHER (AN960JD10L)
56			8	8		MS21042-4	NUT (OR MS21042L4)

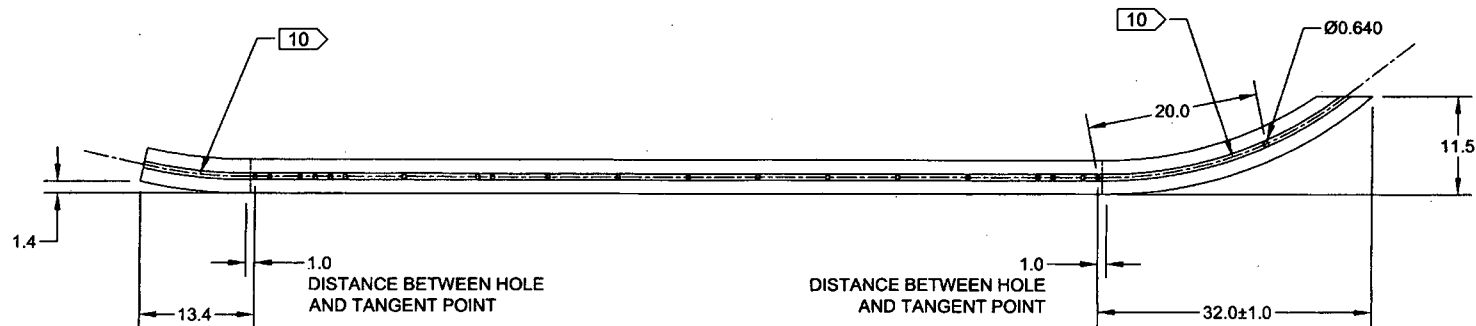
GENERAL NOTES:

- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

RELEASED
2014-04-29

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119903 MJS
14-05-30

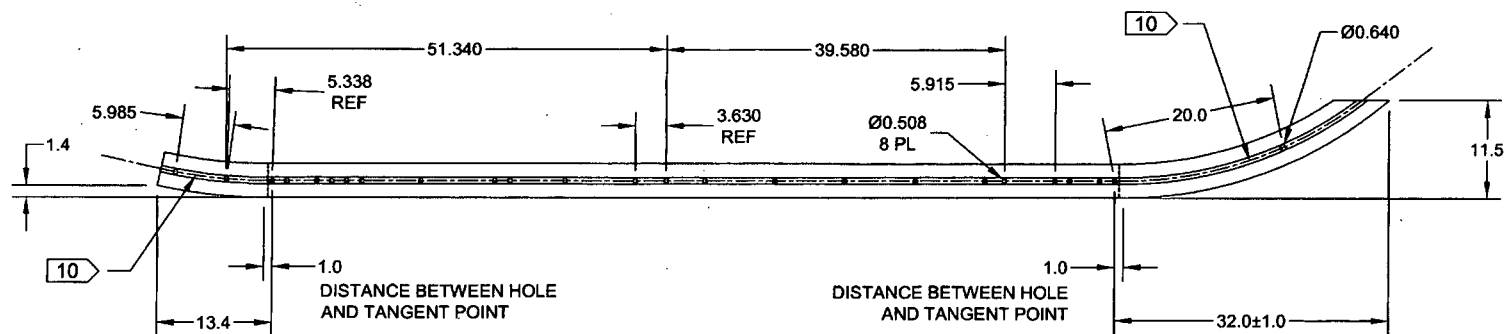
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	DS	D2580	SHEET 1 OF 9
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	205 SKIDTUBE ASSEMBLY	NTS
DATE	14.04.09	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2014-04-29

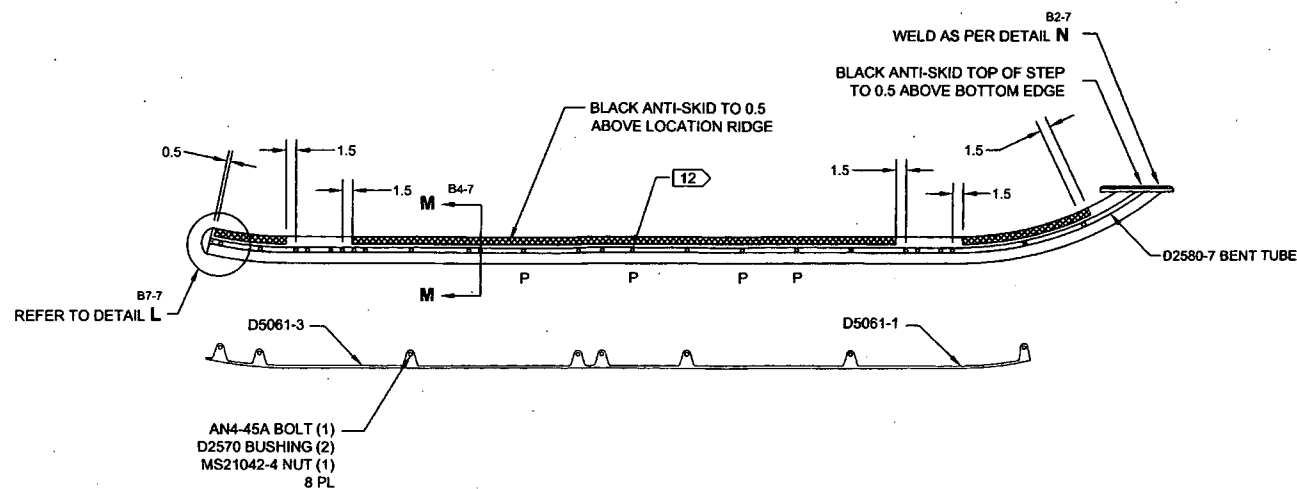
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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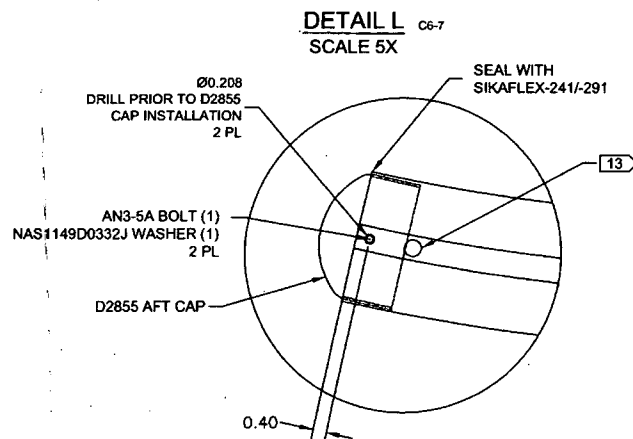
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2014-04-29

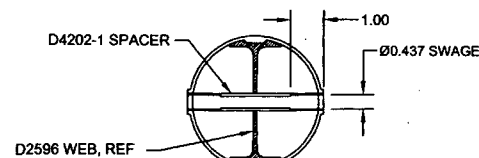
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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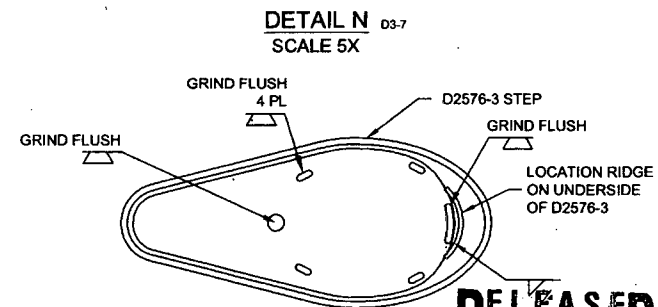
D2580-049 ASSEMBLY DETAIL G



SECTION M-M SCALE 5X D5-7

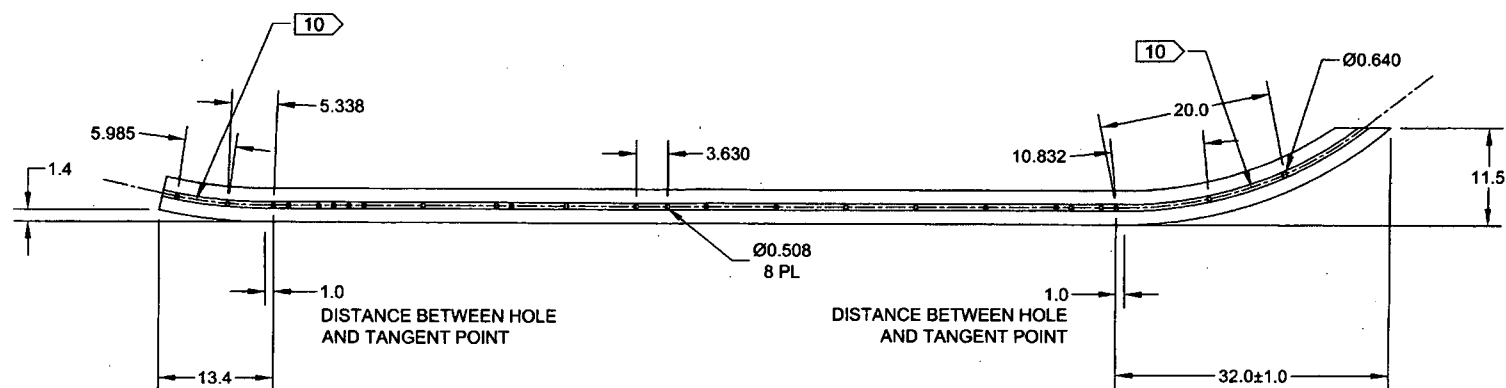


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



RELEASED
2014-04-29

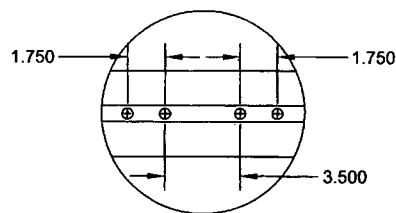
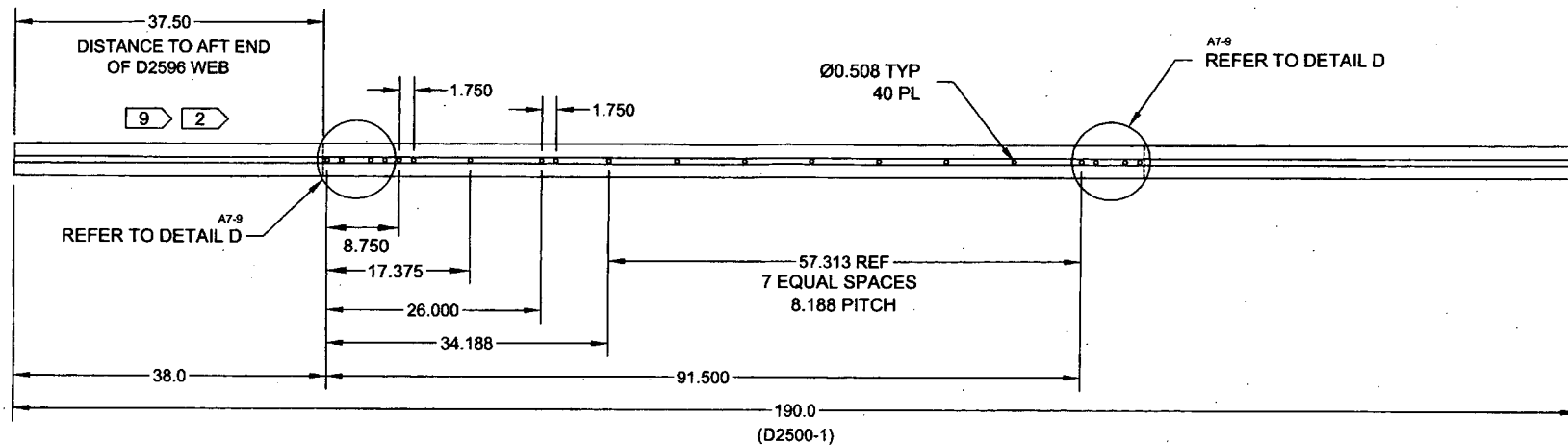
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.J.	DRAWING NO. D2580	REV. G
MFG. APPR.			SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
R 2014-04-29
ND

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	AK	D2580	SHEET 8 OF 9
APPROVED	WNP	TITLE	SCALE
DE APPR.	AK	205 SKIDTUBE ASSEMBLY	NTS
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DETAIL D C3-9
SCALE 5X C7-9

D2580-101 TUBE

RELEASED
2014-04-29
WMD

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	SA	D2580	SHEET 9 OF 9
APPROVED	SW	TITLE	SCALE
DE APPR.	W	205 SKIDTUBE ASSEMBLY	NTS
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~~02/27/14-11~~

Linda Lacelle

From: Patrick Smith
Sent: May-29-14 1:29 PM
To: Linda Lacelle; Mike Petsche
Cc: Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd
Subject: RE: 350 skids and 206 skids

PAR 14-338

Linda,

I spoke with David and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

The existing Plugs would require:

- 1) Removal from the Skidtube
- 2) Removal of the current O-Ring
- 3) Cleaning with Alcohol
- 4) Installation of NEW O-Ring
- 5) Generous coating of the RTV
- 6) Insertion of plug into the Spacer
- 7) Clean up of exterior of Skidtube.

Pat

From: Linda Lacelle
Sent: May-29-14 10:21 AM
To: Mike Petsche
Cc: Nigel Forbes; Patrick Smith; Eric Downing; Nancy MacLeod
Subject: 350 skids and 206 skids
Importance: High

I heard yesterday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution found to fix this problem? Can we not just sikaflex them in or something? We need to let the customer know if his order is shipping or not...

Thx
Linda

~~02/27/14-11~~